

Date: Thursday, 3/23/2006 3:52:24 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 26371		Part Number	: D29392		
Estimate Number	: 10937		Drawing Number	: D2939 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 3/23/2006		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 3/23/2006		Due Date	: 4/10/2006		
Previous Run	: 24961		Qty:	4 Um: Each		
Written By	<u>Specs comment below</u>					
Checked & Approved By	<u>dkj 06.03.24</u>					
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D6101001	7075-T7351 2X6X6.25		
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length <u>B24890</u> Batch No: <u>B25437</u>		JL 06.04.15 (4)
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1		
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr		JL 06.04.16 (4)
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE		
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet		JL 06.04.16 (4)
4.0	QC1	INSPECT ALL DIM TO DIM SHEET		
		Comment: INSPECT ALL DIM TO DIM SHEET		JL 06.04.16 (4)
5.0	QC8	SECOND CHECK		
		Comment: SECOND CHECK		JL 06.04.16 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2939-2 PAR #: N/A Fault Category: Prod / Machined ^{parts} NCR: Yes No DQA:  Date: 06/04/19
QA: N/C Closed:  Date: 06.04.19

NCR: 26371		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.04.17	2	Wrong program run on machine. D2932-2 was made B# B26371. operator error, punched in wrong folio #		Fix folio to A D2939-2 B26371. Add D2932-2 B26371 to W/O D2932-2 B24854, Replace Saccine See attached doc.	JL 06.04.17		 06/04/17	 06/04/17

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:52:24 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 26371

Part Number: D29392

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	<i>a.m 06-04-18 4</i>
7.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	<i>a.m 06-04-18 4</i>
8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT	<i>1/4/10 (4)</i>
9.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	<i>18 06/04/18 (4)</i>
10.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	<i>18 06/04/19 (4)</i>

Job Completion



in 06/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	26371
Description: 206 Saddle, Inboard, Right side				Part Number:	D2939-2
Inspection Dwg: D2939 Rev. B				Page 1 of 1	

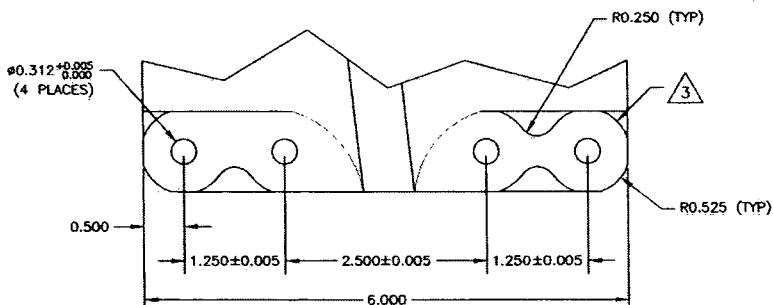
Inspect dimensions highlighted on inspection sheet drawing D2939 Rev. B and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.124	.122	.122	.122		
B	0.100	0.140		.123	.122	.123	.123		
C	0.100	0.140		.120	.121	.120	.120		
D	0.210	0.230		.223	.221	.222	.224		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.499		
H	0.510	0.515		.513	.513	.513	.513		
I	1.572	1.582		1.577	1.576	1.577	1.578		
J	2.495	2.505		2.500	2.499	2.500	2.500		
K	0.257	0.262	DT8683	/	/	/	/		
L	0.312	0.317	DT8686	/	/	/	/		
M	0.235	0.240		.240	.239	.240	.239		
N	0.100	0.140		.117	.116	.118	.117		
O	0.540	0.560		.550	.547	.548	.547		
P	0.490	0.510		.499	.500	.500	.501		
Q	3.715	3.725		3.718	3.719	3.719	3.718		
R	2.720	2.760		2.750	2.750	2.750	2.750		
S	0.240	0.270		.251	.252	.253	.250		
T	0.100	0.180		.140	.140	.140	.140		
U	1.625	1.635		1.630	1.629	1.629	1.630		
V	1.362	1.372		1.364	1.367	1.367	1.366		
W	0.316	0.321	DT8690	/	/	/	/		
X	1.250	1.270		1.258	1.260	1.261	1.261		
Y	1.565	1.585	DT8695 A/B	1.565					
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	J.L.
Date:	06/04/15

Audited by:	J.L.
Date:	06/04/15

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	#

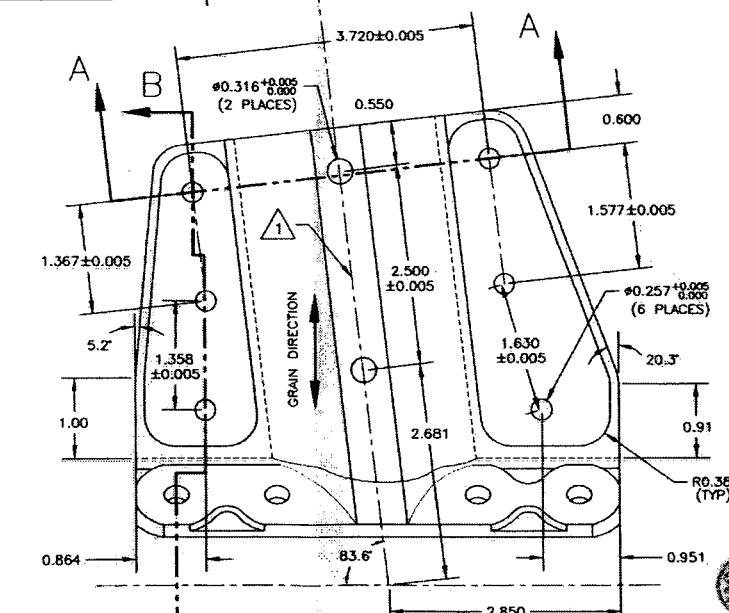
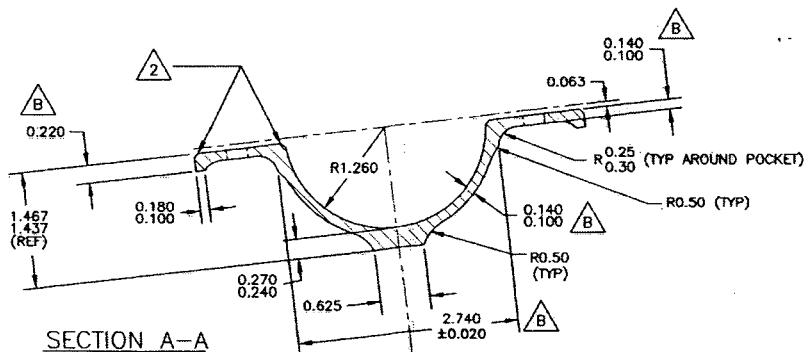
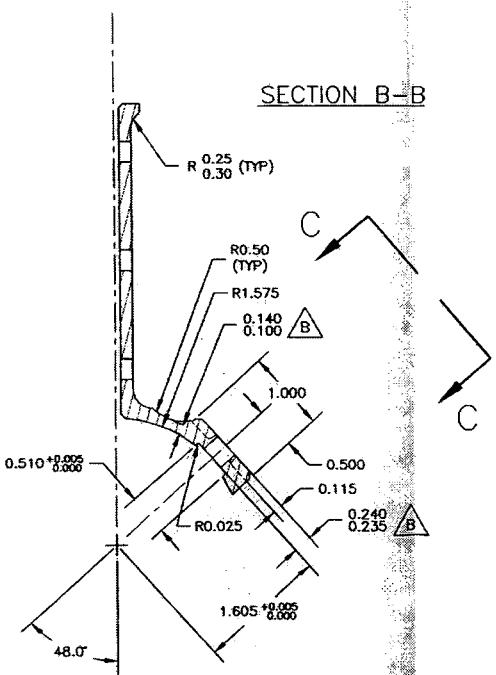


VIEW C-C

D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

MATERIAL: 7075-T7351 (QQ-A-250/12)
 FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4.3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP
- 2 CHAMFER 0.050" x 45° AROUND THIS SURFACE (TYP 2 PLACES)
- 3 CHAMFER 0.050" x 45°



B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. BELLLEVUE, WA
CHECKED	APPROVED	DRAWING NO. D2939
DATE		REV. B SHEET 1 OF 1 TITLE SADDLE INSIDE SCALE 2:3
00.05.29		

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 NO. 26371
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 ENGINEERING

Date: Monday, 11/21/2005 1:16:27 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, OUTBOARD, RIGHT SIDE		
Job Number	: 24854					
Estimate Number	: 10832					
P.O. Number	:			Part Number	: D29322	
This Issue	: 11/21/2005		S.O. No. :	Drawing Number	: D2932 REV B	
Prsh Rev.	: NC			Project Number	:	
First Issue	: / /		Type :	Drawing Revision	: B	
Previous Run	:			Material	:	
Written By	:			Due Date	: 12/21/2005	
Checked & Approved By	:			Qty:	4 Um: Each	
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101003	7075-T7351 2X6.25X7.875
		REFERENCE ONLY
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) 7075-T7351 2X6.25X7.875 Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0 x 6.25 X 7.88 Grain Along Long 7.88 Length Batch No: B 25347	J.L 06.04.17
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2932 & attached Dimension Sheet 5-Deburr	PTO
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
	Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET
	Comment: INSPECT ALL DIM TO DIM SHEET	

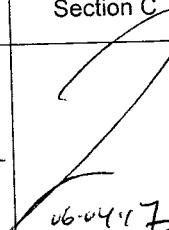
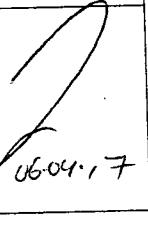
WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

REFERENCE ONLY

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng.	Approval QC Inspector
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-17	2	Chamfer tool was too low so the 4" bars run and the tool ran in along the bottom of the saddle (view c-c) -0.40 deep. that I would be too thin when channel gets machined.		Scrap & destroy. Replace as noted below.	J-L 06-04-17			
06-04-17	2	# D2932-2 B26371 was made on w/o D2939-2 B26371. See for details.		Add D2932-2 B26371 to replace scrap saddle (above) on this w/o	J-L 06-04-17 CL-04-17			

NOTE: Date & initial all entries